

Work Order ID 110036

December-17-13 9:06:42 AM

110036

Page 1

Item ID: 647.0112

Revision ID:

Item Name: Strut Bracket

Start Date: 12/19/13 Start Qty: 16.00

Required Date: 12/19/13 Req'd Qty: 16.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan: AKDate: 12-17-13

QC: _____

Date: _____

Tooling: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

647.0100

A

0.00

0.00

0.00

0.00

100

100

Waterjet

FLOW CNC Waterjet

304.080

FLOW WATER JET

Memo

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

16 0 Im 14-04-916 0 Im 14-04-9

Work Order ID 110036

December-17-13 9:06:42 AM

110036

Page 2

Item ID: 647.0112

Revision ID:

Item Name: Strut Bracket

Start Date: 12/19/13 Start Qty: 16.00

Required Date: 12/19/13 Req'd Qty: 16.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

Quality Control

0.00

130

Form as per dwg

0.00

130

Brake NC

Memo

Brake NC

USE DT9834 FOR FORMING

DAS
30
9-89

0.00

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

Quality Control

0.00

DAS

27

9-89

14/5/9

14/05/05

17

Work Order ID 110036

December-17-13 9:06:42 AM

110036

Page 3

Item ID: 647.0112
 Revision ID:
 Item Name: Strut Bracket
 Start Date: 12/19/13 Start Qty: 16.00 ***16***
 Required Date: 12/19/13 Req'd Qty: 16.00 ***16***
 Reference:

Accept ***N900040100*** Setup Start ***NS1***
 Stop ***NS2***
 Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____
 QC: _____ Date: _____

Tooling: _____ Date: _____
 SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00				16			05 CP 14-05-07
150 SprayPaint Spray Painting	Memo PRIME AS PER DWG NOTE 6 BATCH: <u>127 401</u>	0.00							
160	QC14- Inspect Spray Paint	0.00				16			
160 QC Quality Control	Memo	0.00							
170	Identify as per dwg & Stock Location: <u>51535</u>	0.00				16X			DAS 28 9-89 MAY 08 2014
170 Packaging Packaging	Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***	0.00							

Work Order ID 110036

December-17-13 9:06:42 AM

110036

Page 4

Item ID: 647.0112

Revision ID:

Item Name: Strut Bracket

Start Date: 12/19/13 Start Qty: 16.00

Required Date: 12/19/13 Req'd Qty: 16.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center ID

180

180

QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

MLJ 14-05-08

14-05-08

Picklist Print

December-17-13 9:06:41 AM

Page 1

Work Order ID: 110036
 Parent Item: 647.0112
 Parent Item Name: Strut Bracket
 Comments: IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS



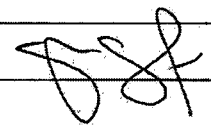
Start Date: 12/19/13 Required Date: 12/19/13
 Start Qty: 16.00 Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S14GA 304SS sheet .080		Purchased	No			100	sf	131.4500	0.0325	①			Jm 14-04-9
-------------------------------	--	-----------	----	--	--	-----	----	----------	--------	---	--	--	------------

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	131.45	
117933	4.5	
119276	9.7	
M126075	117.25	

26075.

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03985			SHEET 1 OF 2	
	DWG NO. 647.0100	REV: A	PREPARED BY J. BECKER	DATE: 7/15/13	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.
	DWG TITLE: SHEET METAL				
	APPROVED BY: ENGR 	MFG 	QC 	EFF. NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED NOTE 2. ADDED 647.0117				

110034
R13-12-17

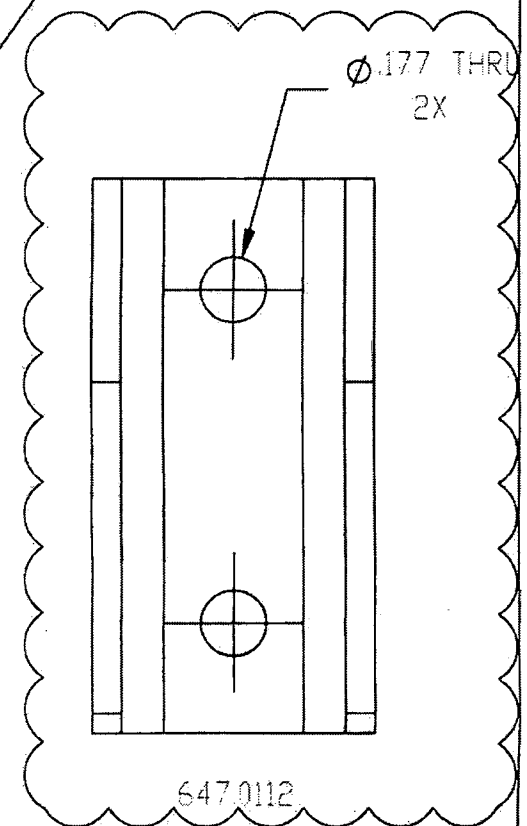
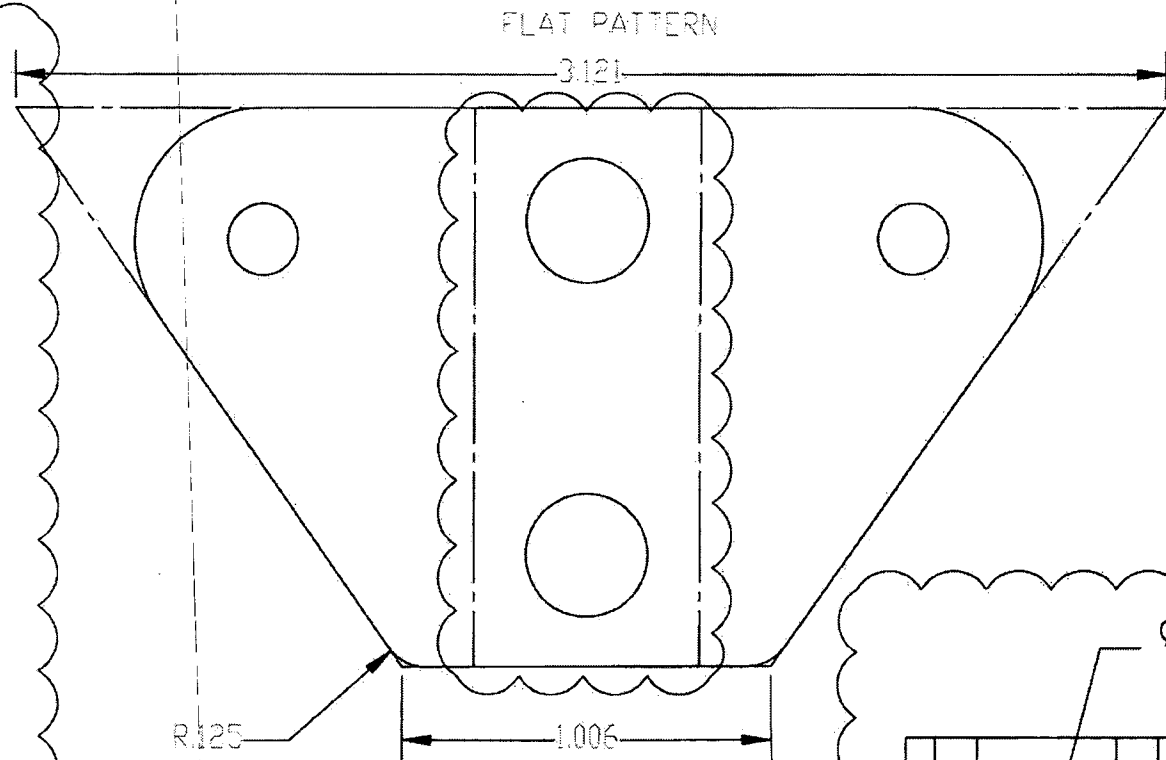
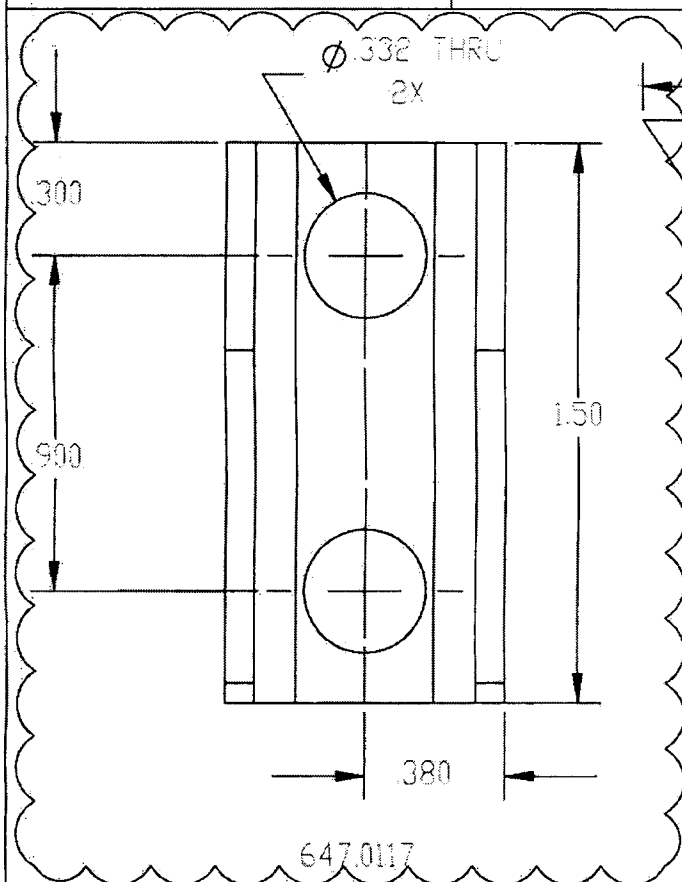
IS

NOTES:

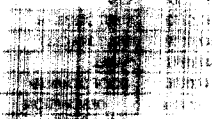
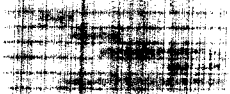
- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- 2 FINISH: IAW MPP-172 ANODIZE IAW SECTION 2.1, PRETREATMENT IAW SECTION 3.1 AND PRIMER IAW SECTION 4.1.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-T20.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.
- 7 OTHER DIMENSIONS SAME AS 647.0112.

SHEET 1, ZONE D1 IS:

C	647.0117	STRUT BRACKET		△	△
F/N	TC	PART NUMBER	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:			CHANGE CATEGORY	DER REVIEW REQUIRED	
<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUCTIONS <input type="checkbox"/> ICA <input type="checkbox"/> FMS <input type="checkbox"/> BOM			<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	

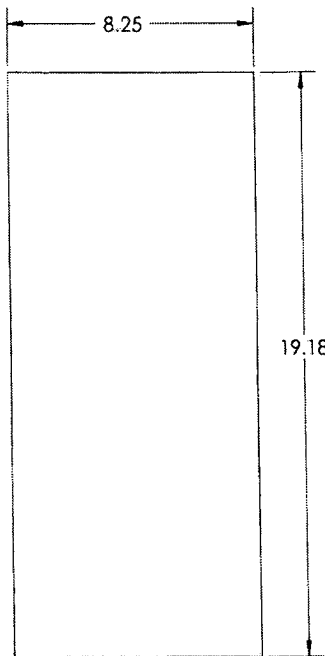
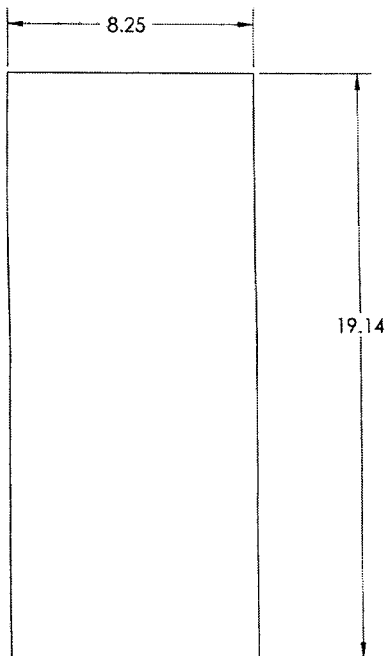


SHEET 3, ZONE B2-4 IS:

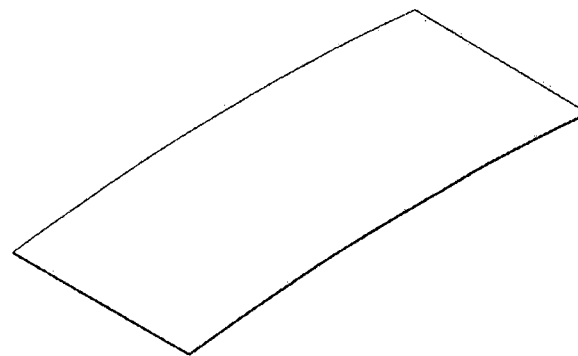


1. *Chrysomelidae*

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



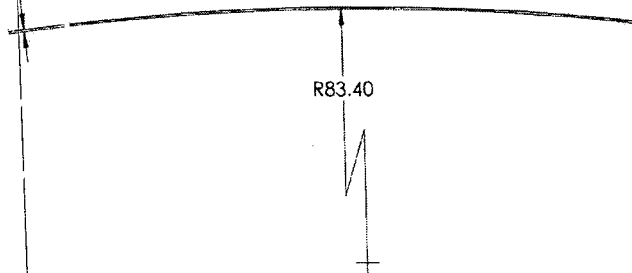
FLAT PATTERN



647.0111



.063



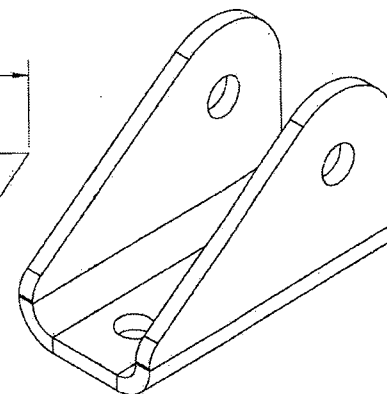
ORIGINAL DATE 11/10/04 BY: SS/SS OF DRAWN BY: DIRECTOR R. ROSANO P. BRAYO DRAWING APPROVAL P. BRAYO		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. PLACE DECIMALS ± .01 2. PLACE DECIMALS ± .005 3. PLACE DECIMALS ± .002 ANGLES ± .5°		SIZE CAGE CODE DWG. NO. REV. 8 07M16 647.0100 A	
SCALE: NONE		SHEET 2 OF 6	

THE INFORMATION CONTAINED IN THE DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES AND REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

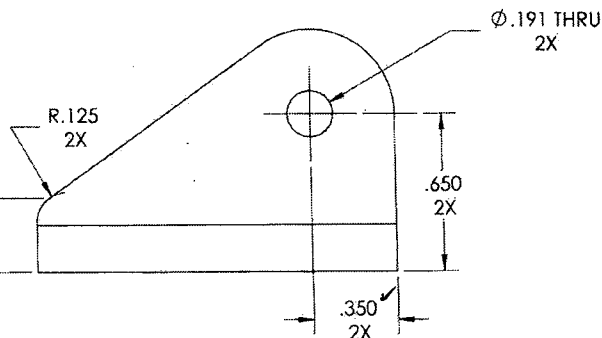
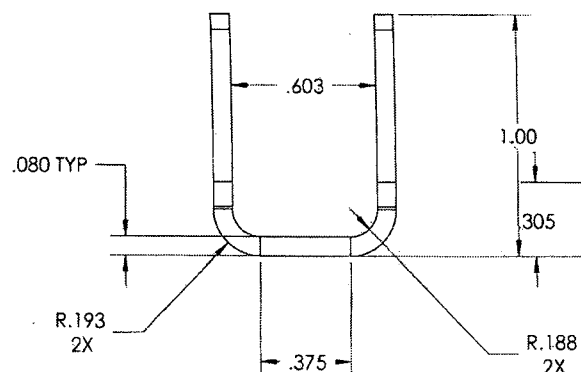
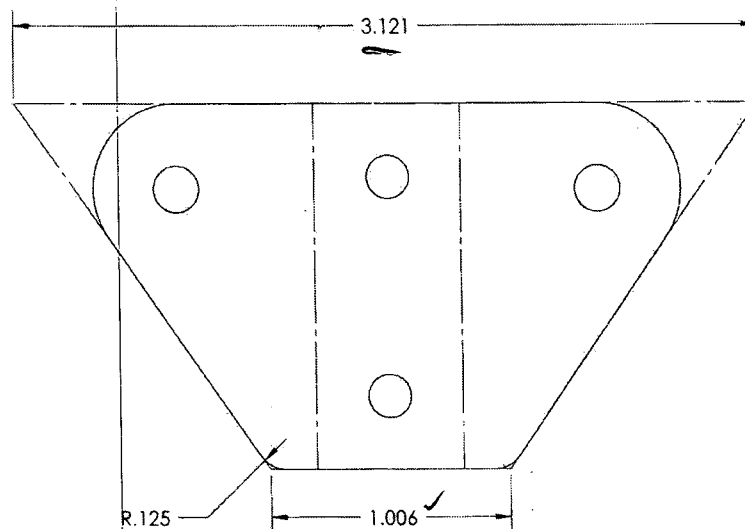
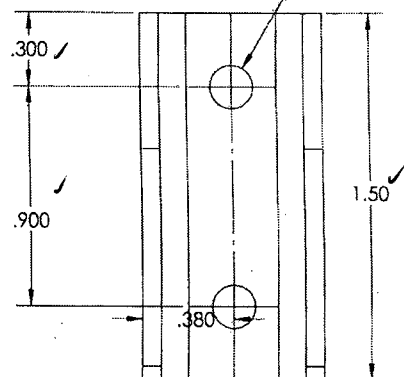
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

Ø.177 THRU
2X

FLAT PATTERN



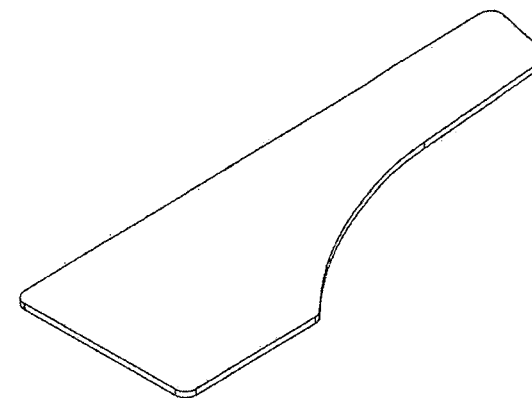
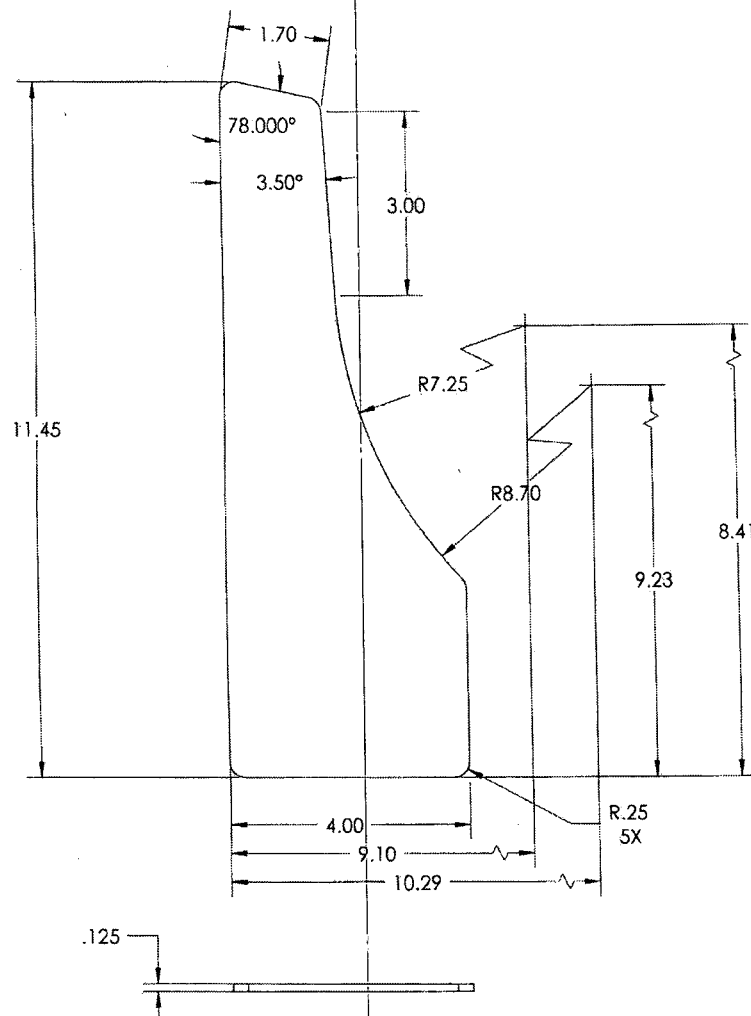
647.0112



ORIGINAL DATE JAN 1981		DESIGNED BY R. BROWNE		DRAWN BY P. BRAYO	
DRAWING APPROVAL P. BRAYO		CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET METAL		DWG. NO. 647.0100	
SCALE NONE		SHEET 3 OF 6		REV. A	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REV.	DESCRIPTION	DATE	APPROVED

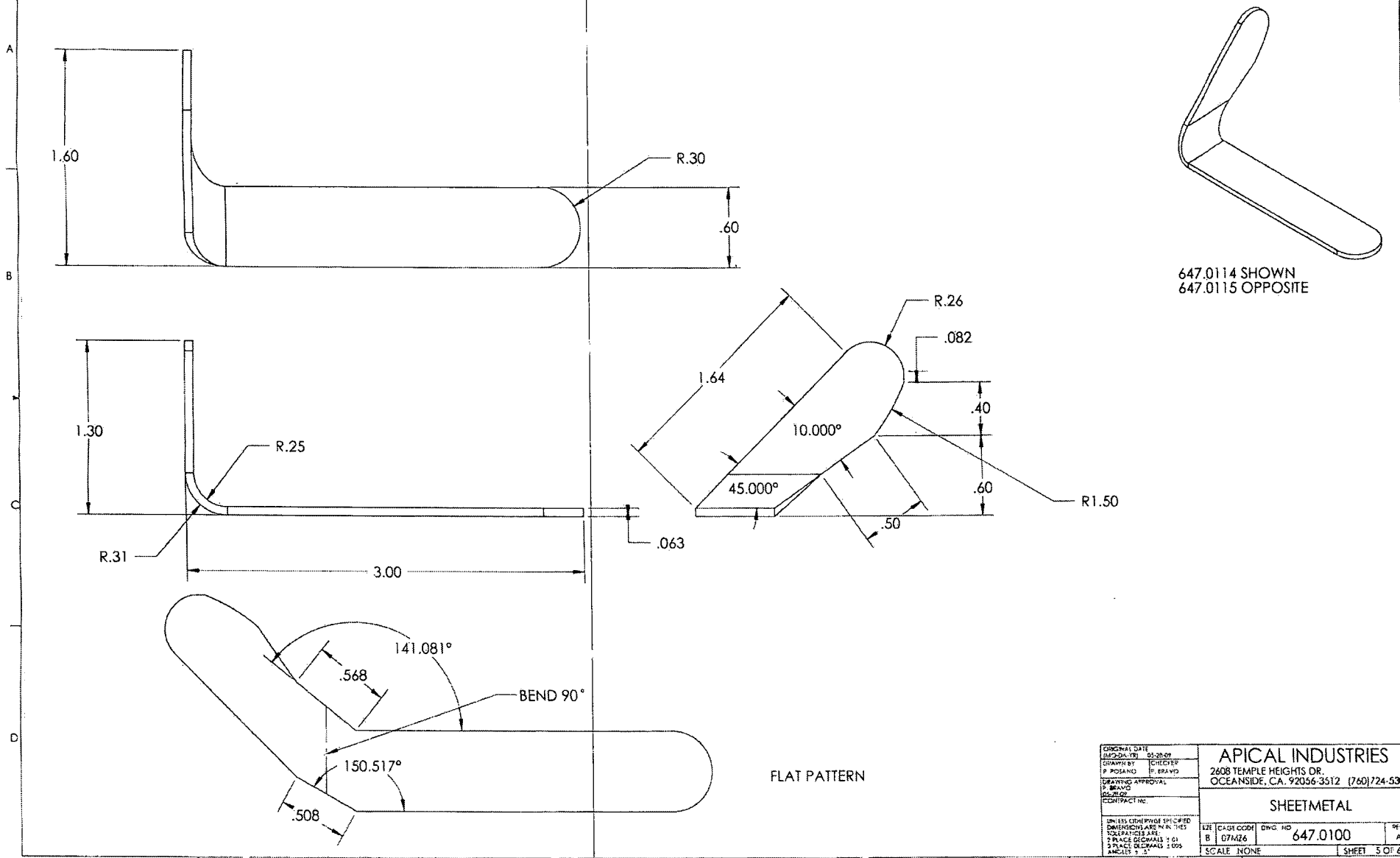


647.0113

ORIGINAL DATE 12/02/2011	DATE 05/26/09	APICAL INDUSTRIES	
DRAWN BY P. ROSANO	CHECKER P. BRAVO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO	DATE 05/26/09	SHEETMETAL	
CONTRACT NO.		SHEET B	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°	DATE 05/26/09	SCALE NONE	SHEET 4 OF 6

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

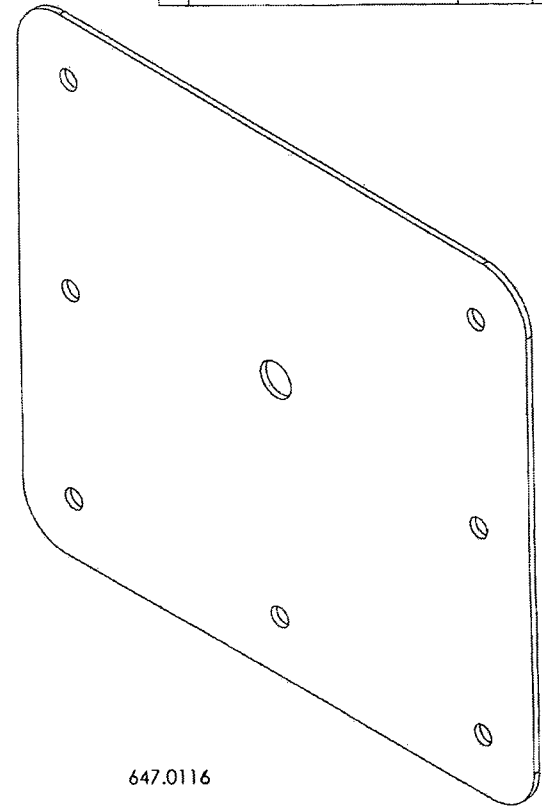
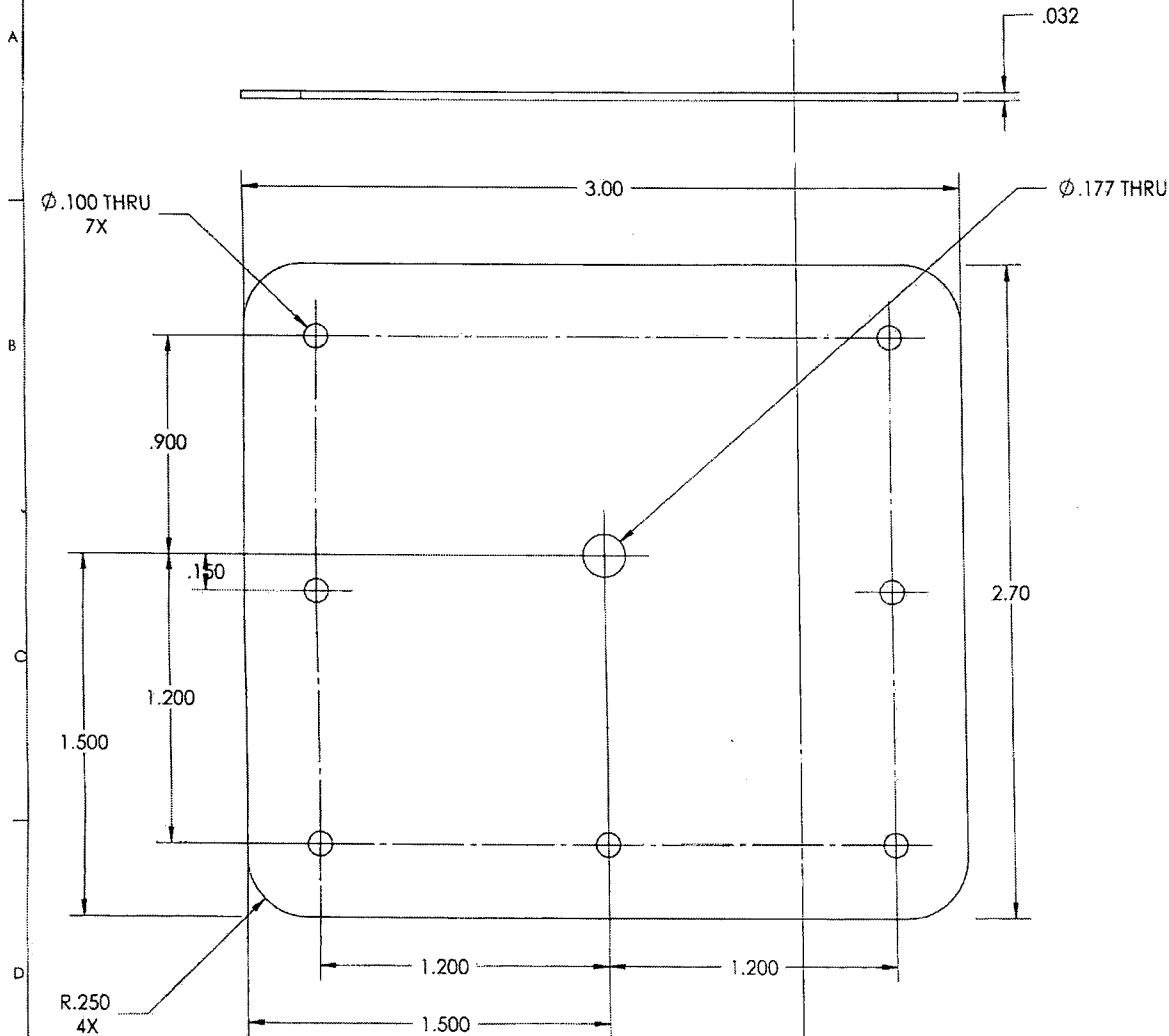
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE 11/20/24-10 05:28:09		APICAL INDUSTRIES	
DRAWN BY P. POSANO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. BRAVO		OCEANSIDE, CA. 92036-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAVO		SHEETMETAL	
DESIGNED BY C. HARTMAN			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		LIT CAGE CODE DWG. NO. REV.	
		B 07M26 647.0100 A	
		SCALE: NONE	SHEET 5 OF 6

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0116

ORIGINAL DATE 1/20/2011 08:30:00		APICAL INDUSTRIES	
DRAWN BY: J. ROYANO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: P. BRAVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO		SHEETMETAL	
CLT/PACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE CAGE CODE B 07M16	DWG. NO. 647.0100
		SCALE NONE	REV A
		SHEET 6 OF 6	

